

Date:
User:Tuesday, 25/11/2008 9:53:34 AM
Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WEARPLATE

Job Number : 43723 - 1

Estimate Number : 10437

P.O. Number :

This Issue : 25/11/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 1/1

Type : SMALL / MED FAB

Previous Run : 42513

Part Number : D33191

Drawing Number : D3319 REV. B

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 02/12/2008

Qty: *Split 6* 12 Um: Each

Written By :

Checked & Approved By : *MF 08-11-25*

Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC

Est Rev: C Now on Waterjet 06-10-26 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1010S18GA

1010/1025 SHEET .048



8.1



Comment: Qty.: 0.6594 sf(s)/Unit Total: 7.9128 sf(s)

106603 X 3 = 2.1

1010/1025/A21/6aA SHEET .048 4.7

109 948 X 2 = 1.4

Batch: 10308917 HB 8-11-25

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: B

HB 8-11-25

Prog Rev: B

2-Deburr if necessary

HB 8-11-25

(13)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-11-25



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Soulub5 (HB)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

u/n Done at step #22
Soulub5

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

SB 03 / 11 / 26

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08 / 11 / 26 (43)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: ?

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod

B M109560

SB 08 / 11 / 26

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08 / 11 / 26 (46)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08 / 11 / 26 (48)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:40
320°
3:10

M-L 08 / 11 / 26

(6x)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FR 08 / 11 / 26 (6)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18
and Stock

Location: SI 496

SS 08/11/27 (x6)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/27



Comment: FINAL INSPECTION/W/O RELEASE

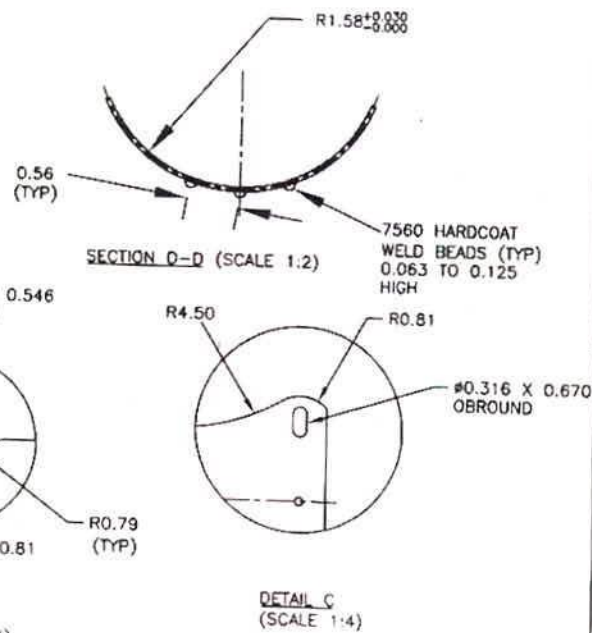
Job Completion



MF 08-11-27

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	P41		DRAWN BY	P41	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED			APPROVED		
DATE	05.06.06		TITLE		D3319
			WEARPLATE		
A	04.09.24		NEW ISSUE		
B	05.06.06		WIDEN HOLES, REDUCE WIDTH -3/-5/-		



RELEASED
05-01-30

Q3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDOM (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

